

MODEL : ***DBC130II***

SERIAL NO : ***DBC***

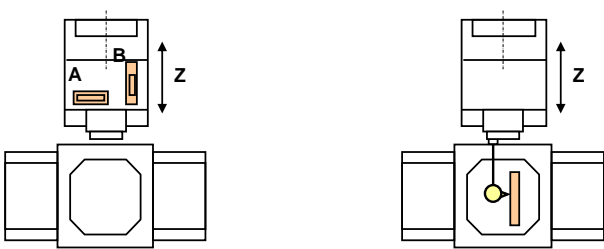
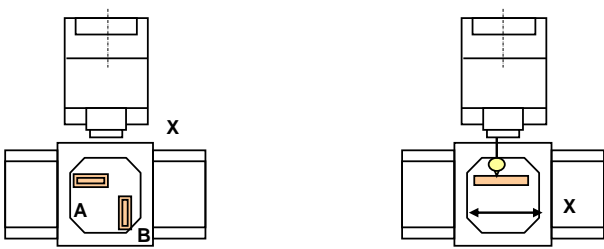
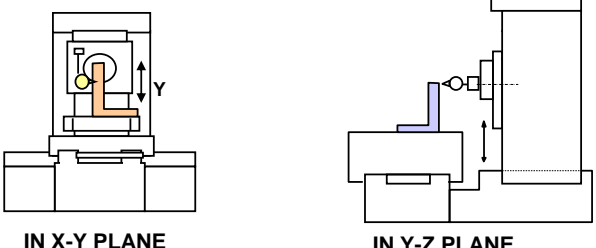
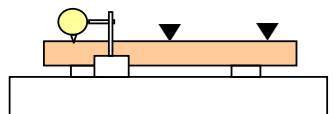
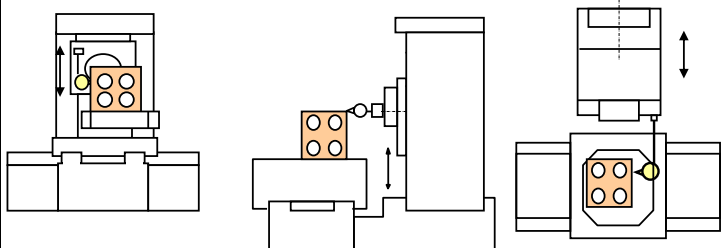
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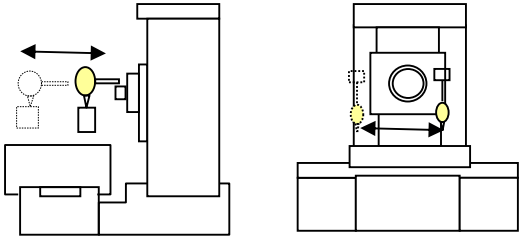
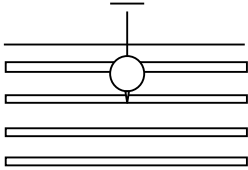

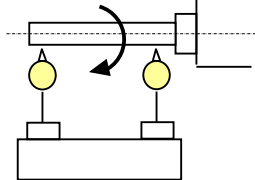
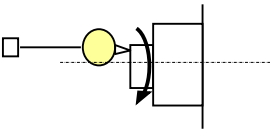
**CNC BORING  
TEST RECORD**

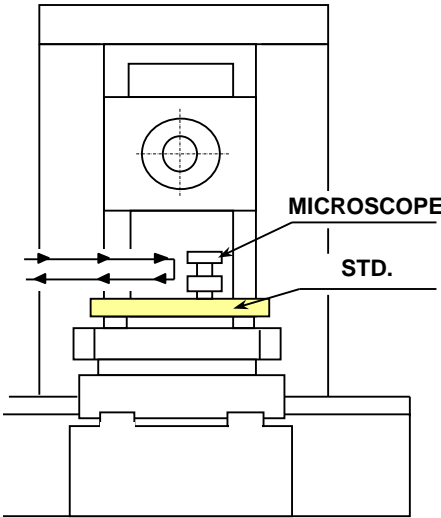
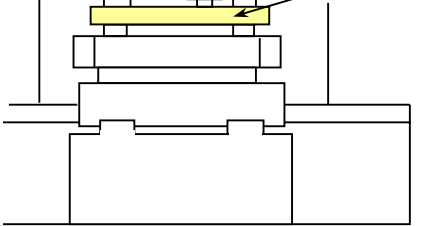


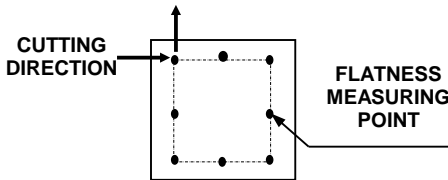
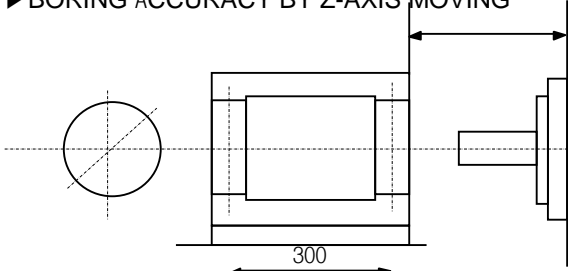
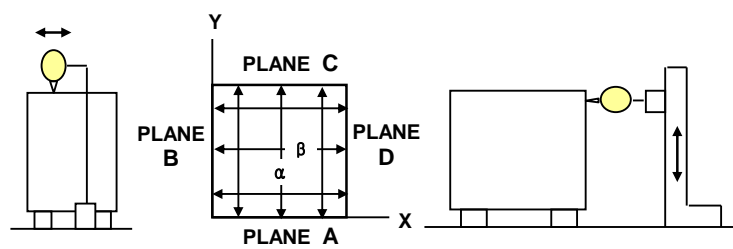
***Doosan Infracore Co., Ltd.***

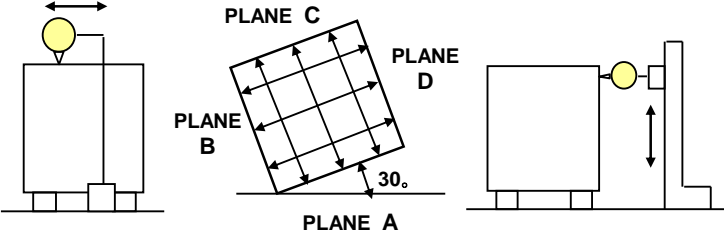
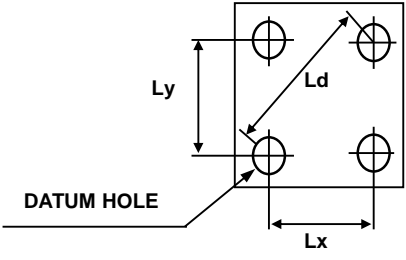
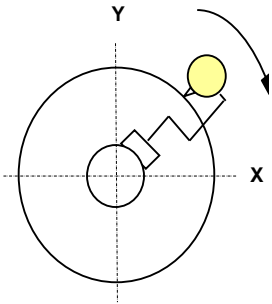
**CHANGWON, KOREA**

DBC130P		GEOMETRICAL TEST		2/5
NO.	TEST ITEM	TOLERANCE		READING
1	▶ STRAIGHTNESS OF Z-AXIS MOVEMENT  A : X DIRECTION IN X-Y PLANE    B : Z DIRECTION IN Y-Z PLANE    Z DIRECTION IN X-Z PLANE	X-Y	0.030 / FULL STROKE	
		Y-Z	0.030 / FULL STROKE	
		X-Z	0.010 / 500	
2	▶ STRAIGHTNESS OF X-AXIS MOVEMENT  A : X DIRECTION IN X-Y PLANE    B : Z DIRECTION IN Y-Z    X DIRECTION IN X-Z PLANE	X-Y	0.030 / FULL STROKE	
		Y-Z	0.030 / FULL STROKE	
		X-Z	0.010 / 500	
3	▶ STRAIGHTNESS OF Y-AXIS MOVEMENT  IN X-Y PLANE    IN Y-Z PLANE	X-Y	0.010 / 500	
		X-Z	0.010 / 500	
4	▶ STRAIGHTNESS OF THE PALLET SURFACE 	X-Y	0.030 / m	
		Y-Z	0.030 / m	
5	▶ MUTUAL SQUARENESS BETWEEN AXES  X-Y    Y-Z    X-Z	X-Y	0.020 / 500	
		Y-Z	0.020 / 500	
		X-Z	0.020 / 500	

DBC130P		GEOMETRICAL TEST		3/5
NO.	TEST ITEM	TOLERANCE		READING
6	▶ PARALLELISM OF AXIAL MOVEMENTS TO THE PALLET SURFACE 	X-AXIS	0.04	
		Z-AXIS	0.03	
7	▶ PARALLELISM OF X AXIS MOVEMENT TO T-SLOT DATUM PLANE 	0.040 / FULL STROKE		
8	▶ PARALLELISM OF Z AXIS MOVEMENT TO THE SPINDLE CENTER 	X-Z	0.015 / 300	
		Y-Z	0.020 / 300	
9	▶ RUN-OUT OF SPINDLE INTERNAL TAPER 	AT SPINDLE NOSE	0.015	
		AT 300 mm DISTANCE	0.030	
10	▶ RUN-OUT OF MILLING SPINDLE NOSE 	0.020		

DBC130P		POSITIONING TEST			4/5
NO.	TEST ITEM		TOLERANCE		READING
1		► POSITIONING ACCURACY (Based on JIS)	X-AXIS	±0.007(with Scale) ±0.010(standard)	
			Y-AXIS	±0.007(with Scale) ±0.010(standard)	
			Z-AXIS	±0.007(with Scale) ±0.010(standard)	
			W-AXIS	±0.010	
			B-AXIS	—	
2		► REPEATABLE POSITIONING ACCURACY (Based on JIS)	X-AXIS	±0.003	
			Y-AXIS	±0.003	
			Z-AXIS	±0.003	
			W-AXIS	±0.003	
			B-AXIS	—	

DBC130P		PRACTICAL CUTTING TEST		
NO.	TEST METHOD	ITEM	TOLERANCE	READING
1	▶ FACE-MILLING ACCURACY  	FLATNESS	0.020	
		STEP ( HEIGHT DIFFERENCE BETWEEN THE INITIAL AND THE END POINT)	0.020	
2	▶ BORING ACCURACY BY Z-AXIS MOVING  	ROUNDNESS	0.015	
		CYLIDRICITY	0.010 / 200	
3	▶ SIDE END-MILLING ACCURACY  	TRAIGHTNES	0.015 / 300	
		PARALLELISM	0.030 / 300	
		DISTANCE DIFFERENCE	0.050	
		SQUARENESS	0.020 / 300	
* PARALLELISM : MAX. DIFFERENCE IN DISTANCE BETWEEN TWO PARALLEL PLANES * α - β : DIFFERENCE IN SURFACE DISTANCE (i.e : A-C & B-D)				

DBC130P		PRACTICAL CUTTING TEST		5/5	
NO.	TEST ITEM	TOLERANCE		READING	
4	<b>▶ LINEAR INTERPOLATION END-MILLING ACCURACY</b>  * PARALLELISM : REFER TO SIDE MILLING ACCURACY	STRAIGHTNESS	0.020 / 300		
		PARALLELISM	0.040 / 300		
		SQUARENESS	0.040 / 300		
5	<b>▶ POSITIONING ACCURACY BY BORING</b> 	PITCH ERROR	EACH AXIS	0.040 / 350	
			DIAGONAL	0.055 / 495	
		HOLE DIAMETER DIFFERENCE		0.010	
6	<b>▶ CIRCULAR INTERPOLATION END-MILLING ACCURACY</b> 	ROUNDNESS	0.050		
<div style="text-align: center;">             INSPECTED BY : _____               APPROVED BY : _____           </div>					